

Date: Monday, 2/19/2007 3:27:04 PM
 User: Kim Johnston

Process Sheet

| | |
|---|--------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : TAIL LIGHT FAIRING |
| Job Number : 30772 | |
| Estimate Number : 12360 | |
| P.O. Number : <i>N/A</i> | Part Number : D34843 |
| This Issue : 2/19/2007 S.O. No. : <i>N/A</i> | Drawing Number : D3484 REV D |
| Prsht Rev. : NC | Project Number : <i>N/A</i> |
| First Issue : <i>N/A</i> Type : SMALL /MED FAB | Drawing Revision : D |
| Previous Run : 27223 | Material : <i>N/A</i> |
| Written By : <i>[Signature]</i> | Due Date : 3/10/2007 Qty: 5 Um: Each |
| Checked & Approved By : <i>[Signature]</i> 07.02.19 | |
| Comment : Est Rev: A New Issue 06-04-11 JLM | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|-------------|--------------------|
| 1.0 | M6061T6S050 | 6061-T6 .050 Sheet |
|-----|-------------|--------------------|



Comment: Qty.: 0.0565 sf(s)/Unit Total : 0.2825 sf(s)

6061-T6 .050 Sheet

(M6061T6S050)

Batch: *117347**SAD 07/02/24**5*

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET

Cut as per Dwg D3484

*SAD 07/02/24**6*

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SAD 07/02/24**5*

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

*SG 07.02.25**5*

| | | |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr *SAD 07/02/25 (5)*

2-C'sink as per Dwg D3484

m 07/03/05 x5

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PP Date: 07/04/11
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 2/19/2007 3:27:04 PM
User: Kim Johnston

Process Sheet

✓ Customer: CU-DAR001 Dart Helicopters Services Drawing Name: TAIL LIGHT FAIRING
Job Number: 30772 Part Number: D34843

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

207/03/20 (5)

7.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

207/04/10 (5)

8.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

FD 07/10/11 (5)

Job Completion



U 07/04/11

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

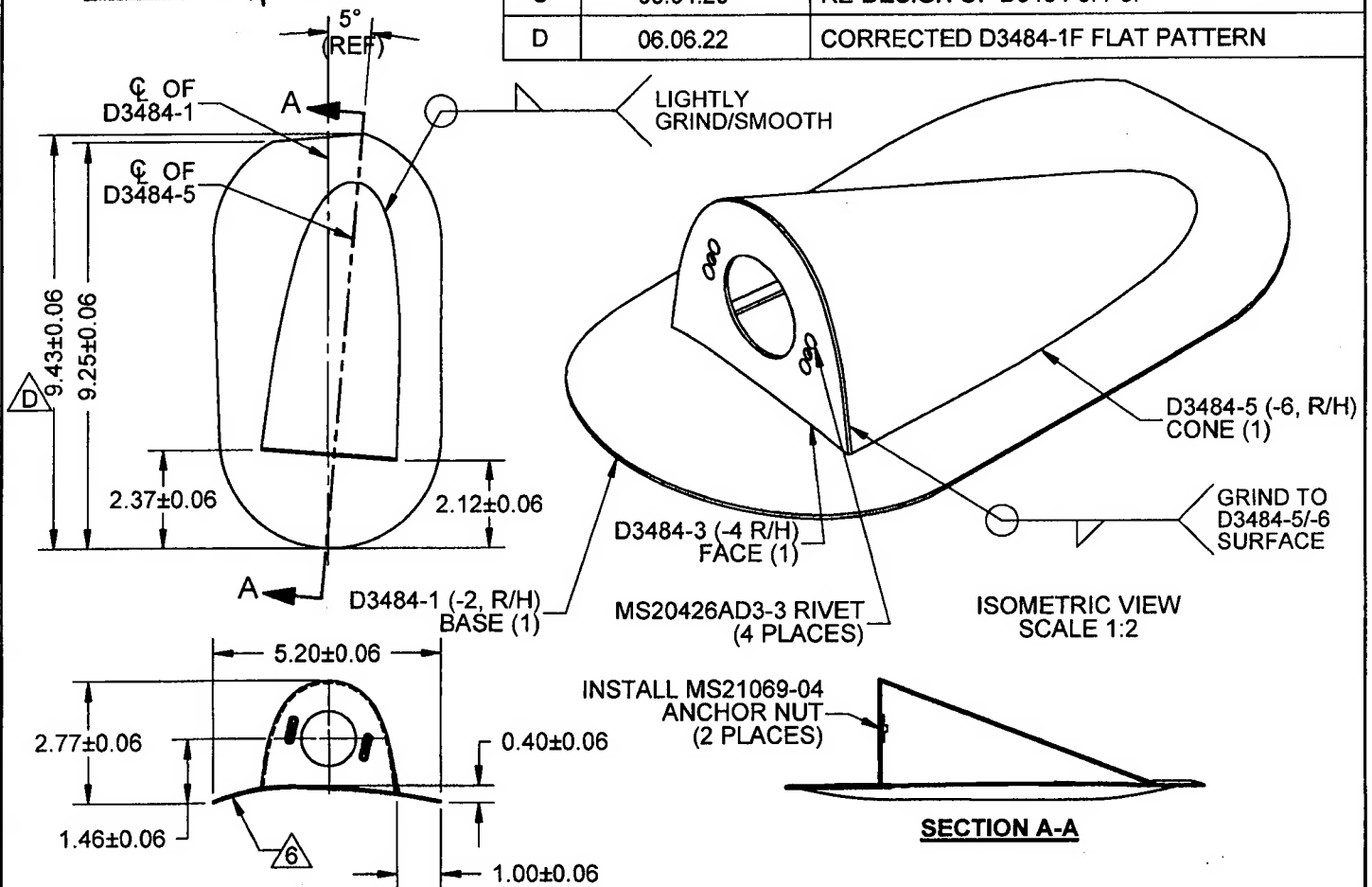
NOTE: Date & initial all entries

DART

| | | | |
|-------------------------|------------------------------------|--|------------------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. D3484 | REV. D SHEET 1 OF 4 |
| DATE 06.06.22 | TITLE TAIL LIGHT FAIRING | | SCALE 1:4 |
| A | 05.11.29 | NEW ISSUE | |
| B | 06.02.21 | RE-DESIGN | |
| C | 06.04.20 | RE-DESIGN OF D3484-3F/-5F | |
| D | 06.06.22 | CORRECTED D3484-1F FLAT PATTERN | |

RELEASED

06.08.17

**D3484-041 TAIL LIGHT FAIRING, L/H (SHOWN), R/H (OPPOSITE)****NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED WITH WHITE LABEL:
"TCCA-PDA, DART AEROSPACE LTD.,
P/N D412-750-141/-142 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE
PDA06-13"

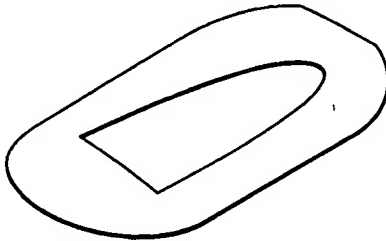
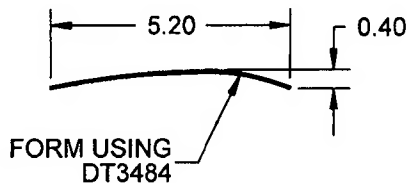
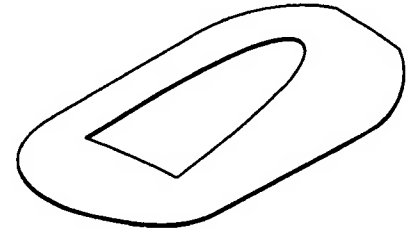
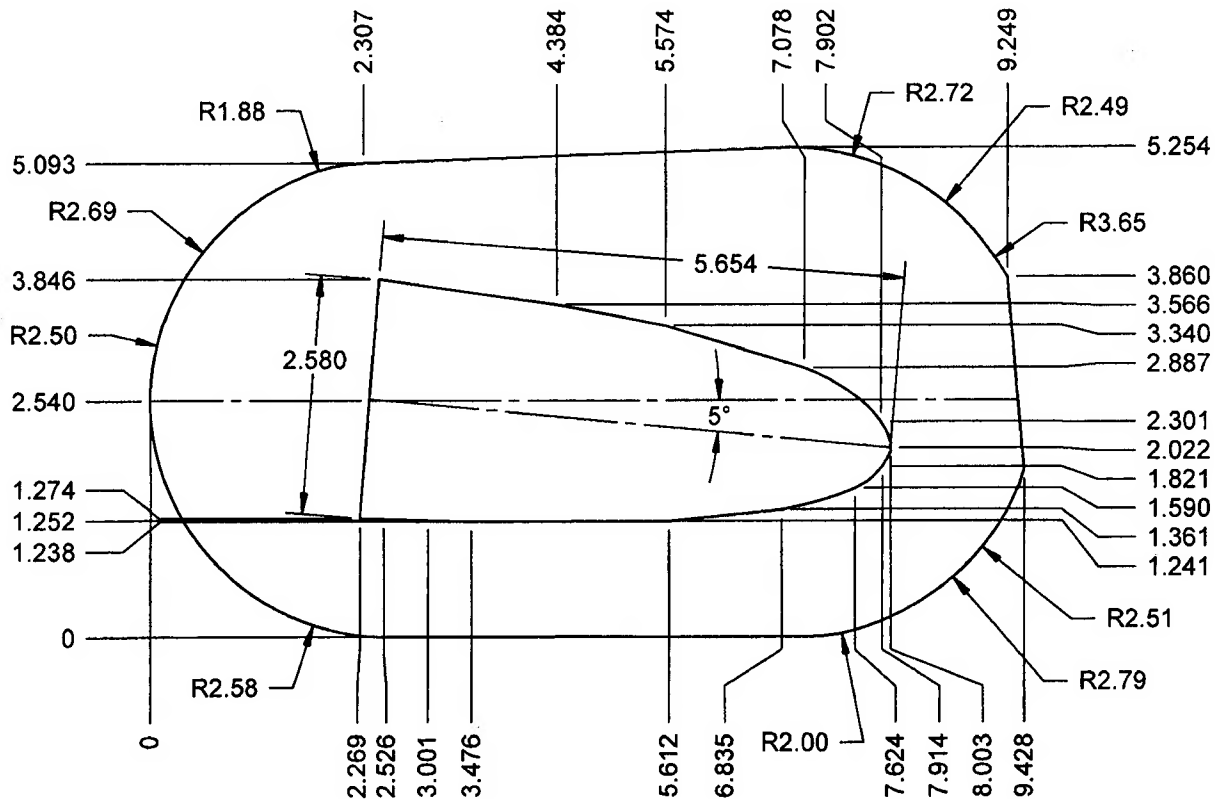
| QTY -041 | QTY -042 | P/N | DESCRIPTION |
|-------------|-------------|--------------|-----------------------------------|
| X | | D3484-041 | TAIL LIGHT FAIRING ASSEMBLY (L/H) |
| | X | D3484-042 | TAIL LIGHT FAIRING ASSEMBLY (R/H) |
| 1 | | D3484-1 | BASE (L/H) SHOP COPY |
| | 1 | D3484-2 | BASE (R/H) RETURN TO |
| 1 | | D3484-3 | FACE (L/H) ENGINEERING |
| | 1 | D3484-4 | FACE (R/H) |
| 1 | | D3484-5 | CONE (L/H) UNCONTROLLED COPY |
| | 1 | D3484-6 | CONE (R/H) SUBJECT TO AMENDMENT |
| | | | WITHOUT NOTICE |
| 4 | 4 | MS20426AD3-3 | RIVET WORK ORDER |
| 2 | 2 | MS21069-04 | ANCHOR NUT NO. 30772 |

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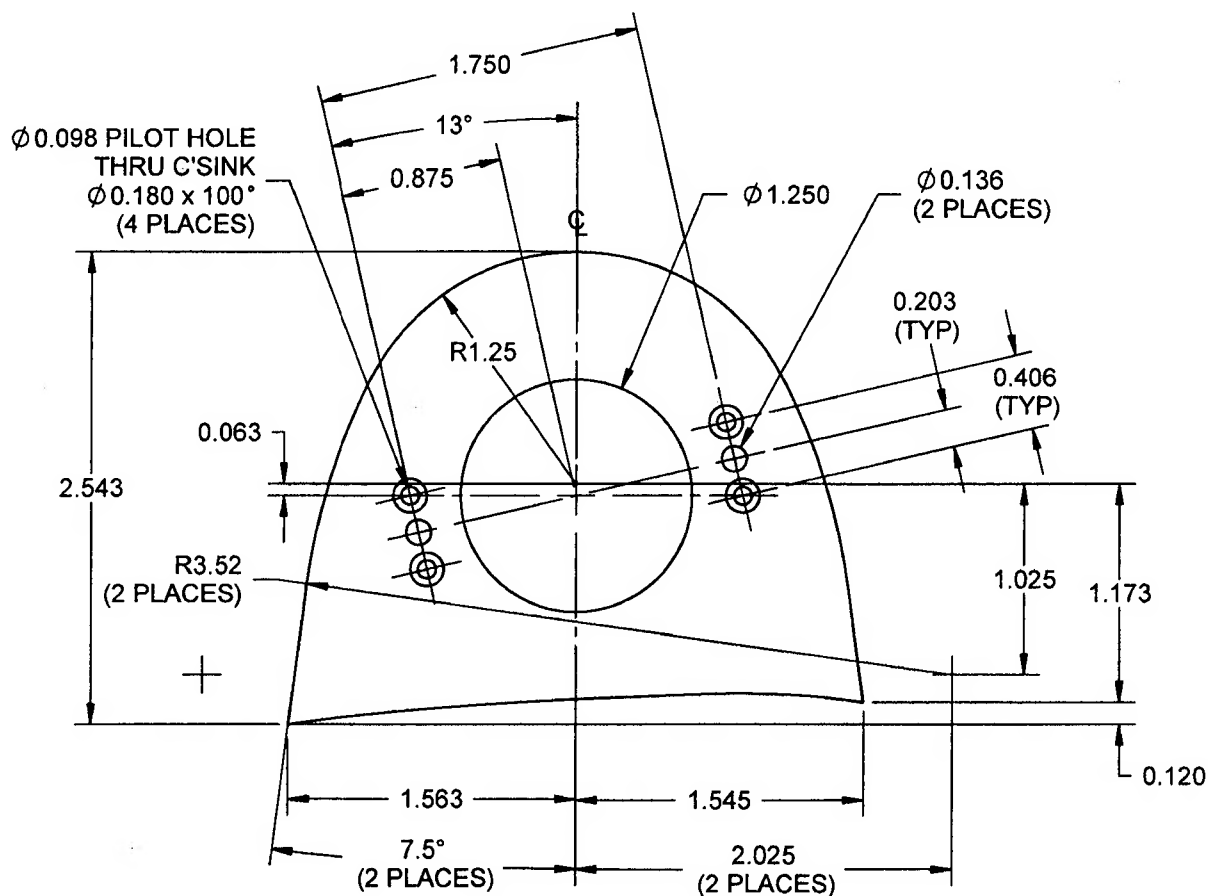
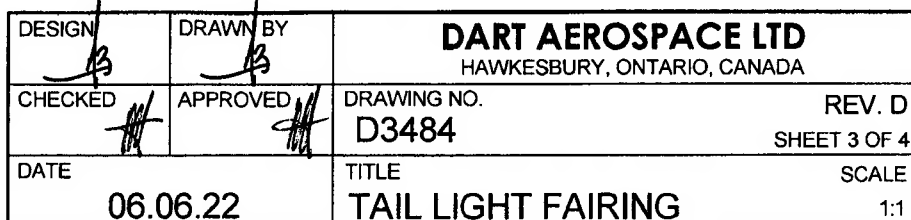
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| DESIGN <i>B</i> | DRAWN BY <i>B</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>H</i> | APPROVED <i>H</i> | DRAWING NO. D3484 | REV. D SHEET 2 OF 4 |
| DATE 06.06.22 | TITLE TAIL LIGHT FAIRING | | SCALE 1:2 |

**D3484-1 BASE, L/H****D3484-1 BENDING DETAIL**
(D3484-2 OPPOSITE)
(MAKE FROM D3484-1F)**D3484-2 BASE, R/H****D3484-1F BASE FLAT PATTERN** **NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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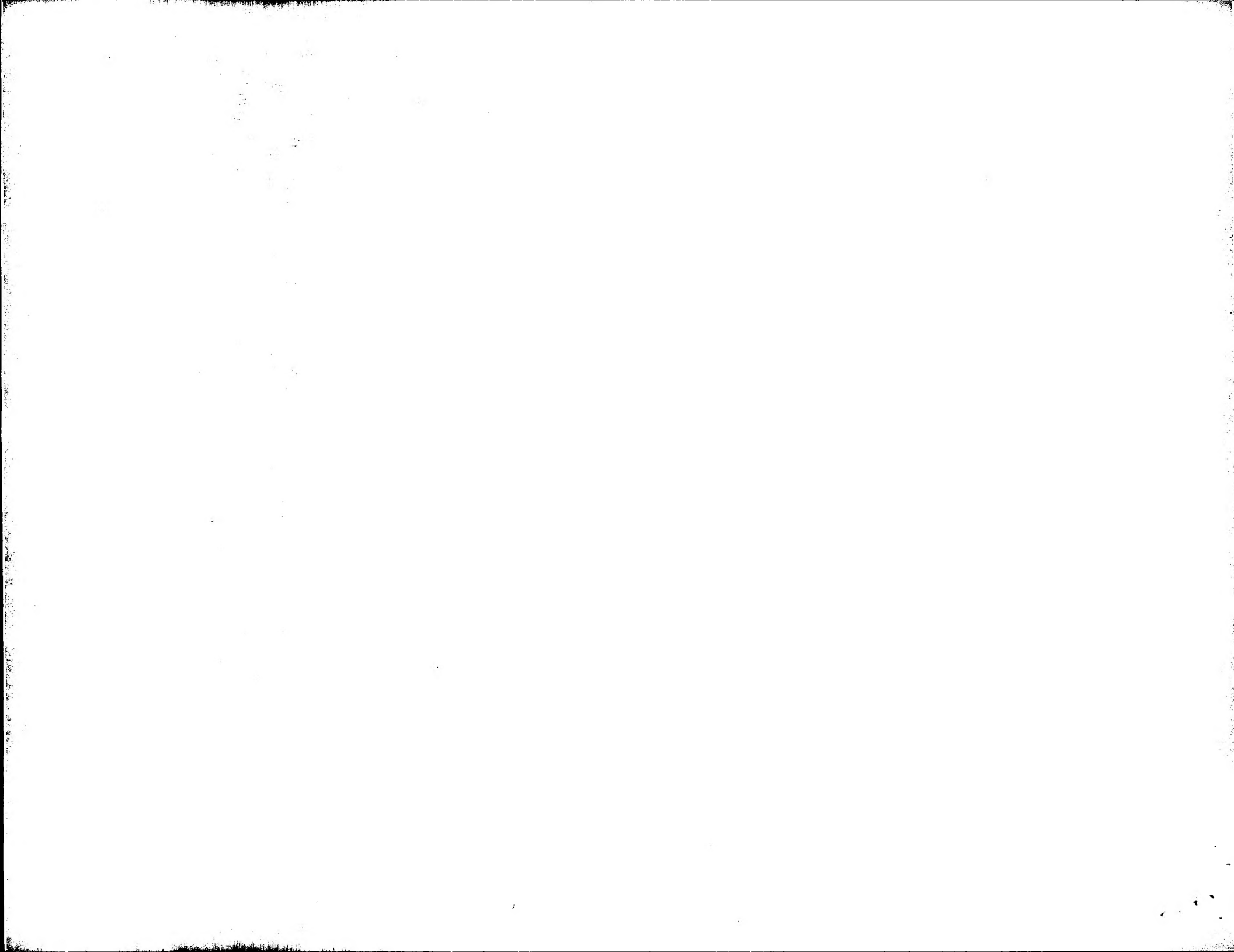
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- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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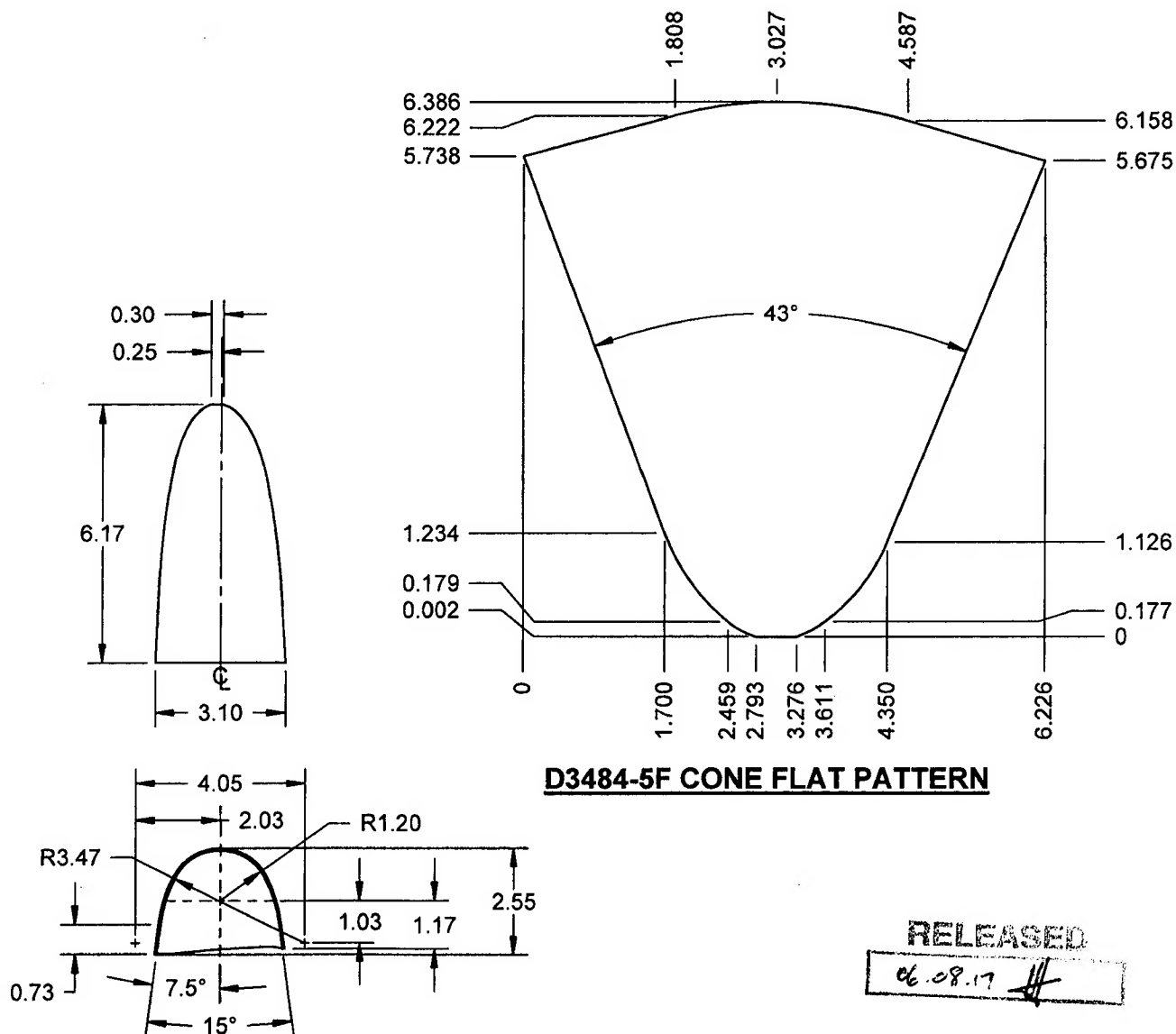
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| CHECKED # | APPROVED # | DRAWING NO. D3484 | REV. D SHEET 4 OF 4 |
| DATE 06.06.22 | | TITLE TAIL LIGHT FAIRING | SCALE 1:4 |



D3484-5F CONE FLAT PATTERN

RELEASED
06.08.17 #

D3484-5 L/H CONE BENDING DETAIL (-6 R/H, OPPOSITE)
(MAKE FROM D3484-5F)

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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
FIRST ARTICLE INSPECTION CHECKLIST

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|-------------------------------------|---------------|-------------------------------------|-----------|

[illegible]

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| Measured by: | SAD |
| Date: | 07/02/24 |

| | |
|--------------------|---|
| Audited by: |  |
| Date: | 07.02.21 |

| | |
|---------------------|---|
| Prototype Approval: |  |
| Date: | |

| | | | | |
|-----|------|-----------|------------|----------|
| Rev | Date | Change | Revised by | Approved |
| A | | New Issue | KJ/JLM | |